

IN THE CLAIMS:

1. (Currently Amended) A cold forming process for manufacturing ball pivots with a ball area, the process comprising:

_____ manufacturing a cone area and a thread area for installation in ball and socket joints, in
which a ball pivot blank (1) with a shaped cone area (3) and cylindrical thread area and
5 cylindrical ball area s for the thread (2) and for the ball (5) is first manufactured from a bar-shaped semifinished bar stock by extrusion, wherein ~~the~~ an extrusion flash is arranged at the free end of the ball area (5) ~~provided for forming the ball and in which the ball area is;~~

subsequently, ~~formed~~ in at least one other operation, forming a ball by means of a rolling process by rolling forming bodies.

2. (Currently Amended) A process in accordance with claim 1, ~~characterized in that~~
wherein the rolling process is a triggered synchronized rolling process.

3. (Currently Amended) A process in accordance with claim 1 ~~or 2, characterized in that~~
wherein the thread area is formed simultaneously with the forming of the ball area into its final shape.

4. (Currently Amended) A process in accordance with ~~one of the claims~~ claim 1
through 3, ~~characterized in that~~ wherein the cone area (4) ~~formed in the preceding pressing~~
~~process~~ is smoothed simultaneously with the forming of the ball area into ~~[[its]]~~ a ball final

shape.

5. (Currently Amended) A process in accordance with ~~claims~~ claim 1 ~~through 4~~, ~~characterized in that~~ wherein a blind hole-like recess (7), ~~which~~ is opened on ~~[[the]]~~ a front side ~~[[.]]~~ and is pressed into the free end of the ball pivot blank (1) intended for forming the ball area before the rolling operation.

6. (Currently Amended) A process in accordance with claim 5, ~~characterized in that~~ wherein the recess (7) is formed by the upper die used during pressing.

7. (Currently Amended) A process in accordance with ~~one of the claims~~ claim 1 ~~through 6~~, ~~characterized in that~~ wherein a cylindrical neck area (4) is formed at first during rolling between the cone area (3) and the cylindrical ball area (5) ~~provided for forming the ball~~.

8. (Currently Amended) A process in accordance with ~~one of the claims~~ claim 1 ~~through 7~~, ~~characterized in that~~ wherein a flat-jaw rolling process is used as the rolling process.

9. (Currently Amended) A process in accordance with ~~one of the claims~~ claim 1 ~~through 7~~, ~~characterized in that~~ wherein a round-jaw rolling process is used as the rolling process.

10. (Currently Amended) A process in accordance with claim 9, ~~characterized in that~~
the wherein round-jaw rollers used in the round-jaw rolling process are designed as rolling
cylinders (21, 22), which are located next to one another on parallel axes of rotation (19, 20),
and whose outer contour has half of the negative form of the contour of the ball pivot to be
5 rolled, wherein the ball pivot is arranged in a roll gap (11) between the rolling cylinders (21, 22
and 25, 26) during the rolling process.

11. (Currently Amended) A process in accordance with claim 9 ~~or 10~~, ~~characterized~~
~~in that~~ wherein the round-jaw rollers are formed by a rolling cylinder (23), on the one hand, and
by a hollow cylinder concentrically surrounding the rolling cylinder (24), on the other hand,
wherein the outer contour of the rolling cylinder (23) and the inner contour of the hollow
5 cylinder (24) form half of a negative form of the contour form of the ball pivot to be rolled,
which said negative form is variable over the outer circumference and the inner circumference,
and wherein the ball pivot is arranged in the roll gap (11) between the outer contour and the
inner contour of the rolling cylinder (23) and the hollow rolling cylinder (24) during the rolling
process.

12. (New) A cold forming process for manufacturing ball pivots, the process comprising
the steps of:

manufacturing a ball pivot blank with a shaped cone area a cylindrical thread area and
a cylindrical ball area from a bar-shaped semifinished bar stock by extrusion, wherein an

5 extrusion flash is arranged at the free end of the ball area;

 subsequently, in at least one other operation, forming a ball by means of a rolling process by rolling forming bodies.

13. (New) A process in accordance with claim 12, wherein the rolling process is a triggered synchronized rolling process.

14. (New) A process in accordance with claim 12, wherein the thread area is formed simultaneously with the forming of the ball area into its final shape.

15. (New) A process in accordance with claim 12, wherein the cone area is smoothed simultaneously with the forming of the ball area into a ball final shape.

16. (New) A process in accordance with claim 12, wherein a blind hole-like recess is opened on a front side and is pressed into the free end of the ball pivot blank intended for forming the ball area before the rolling operation.

17. (New) A process in accordance with claim 16, wherein the recess is formed by the upper die used during pressing.

18. (New) A process in accordance with claim 12, wherein a cylindrical neck area is

formed at first during rolling between the cone area and the cylindrical ball areal.

19. (New) A process in accordance with claim 12, wherein the rolling process is a round-jaw rolling process using round-jaw rollers designed as rolling cylinders, which are located next to one another on parallel axes of rotation, and whose outer contour has half of the negative form of the contour of the ball pivot to be rolled, wherein the ball pivot is arranged in a roll gap between the rolling cylinders during the rolling process.

20. (New) A process in accordance with claim 12, wherein the rolling process is a round-jaw rolling process using the round-jaw rollers formed by a rolling cylinder, on the one hand, and by a hollow cylinder concentrically surrounding the rolling cylinder, on the other hand, wherein the outer contour of the rolling cylinder and the inner contour of the hollow cylinder form half of a negative form of the contour form of the ball pivot to be rolled, which said negative form is variable over the outer circumference and the inner circumference, and wherein the ball pivot is arranged in the roll gap between the outer contour and the inner contour of the rolling cylinder and the hollow rolling cylinder during the rolling process.